

Work Order ID 98699

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Item ID: D4202-1 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Spacer
 Start Date: 3/20/13 Start Qty: 600.00 *600* Cust Item ID:
 Required Date: 3/22/13 Req'd Qty: 600.00 *600* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00		13-3-21		608	✓		DAS 13 2-89
130 *130* Outsource1 Outsource process - Heat Treat	Outsource process - Heat Treat Memo ***HEAT TREAT AS PER DWG D4202***	0.00 0.00		metcar P10:19402					CZ 13/03/22 608
140 *140* Packaging Packaging	Receive & Inspect for Damage & Mat'l Certs Memo	0.00 0.00				608			SP B-4-12

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 Required Date: 3/22/13 Req'd Qty: 600.00 *600* Customer:
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC6- Inspect dimensions to drawing	0.00							
150						608			
QC	Memo	0.00							
Quality Control									
190	Identify as per dwg & Stock Location: <u>L/C</u>	0.00							
190									
Packaging	Memo	0.00							
Packaging	***STOCK IN SKIDTUBE CELL***								
200	QC21- Final Inspection - Work Order Release	0.00							
200									
QC	Memo	0.00							
Quality Control									

13/4/15

ME
13-4-15

Picklist Print

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Work Order ID: 98699

Parent Item: D4202-1

Parent Item Name: Spacer

Start Date: 3/20/13

Required Date: 3/22/13

Start Qty: 600.00

Required Qty: 600.00

Comments: IPP REV:A NEW ISSUE 10-12-07 JLM VERIFIED:DD IPP REV:B AS PER REV B 11-04-05 JLM VERIFIED BY:DD IPP Rev:C 11.12.19 PER DWG REV.C DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6T0.500W.058 6061-T6 RD Tube .500 x.058W		Purchased	No			100	f	409.1530	0.35	221.05263 228.000'		13-03-21	

Location	Loc Qty	Loc Code
MAT014	409.153	
117084	46.494	
117890	0.2	
119160	3.828	
120935	20.207	
122051	30.424	
122312	8	
124768	300	



228.000'

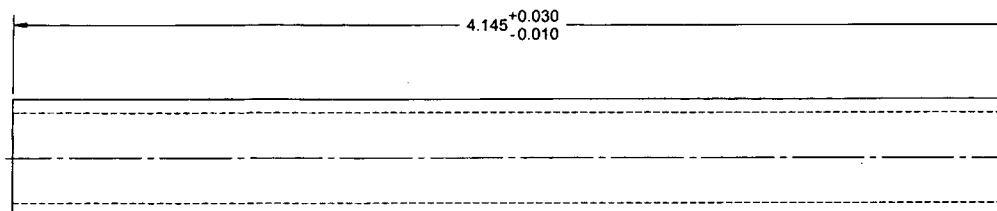
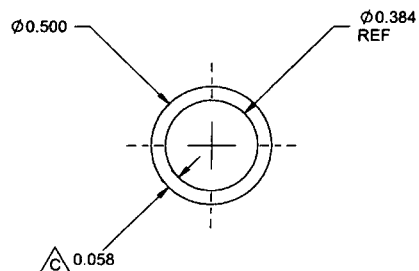
98699

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them

DAS
13
9-89

By	Approved
	



D4202-1 SPACER

RELEASED
2011-12-14

W/O 98699

NOTES:

- 1) MATERIAL: 6061-T4/T42 ALUMINUM TUBING PER WW-T-700/6, AMS 4081, OR ASTM B210 / B221 / B241
REF DART SPEC M6061T4T0.500W.058
OR
6061-T6/T62 ALUMINUM TUBING PER WW-T-700/6, QQ-A-200/8, QQ-A-225/8, AMS 4080 / 4082, OR ASTM B210 / B221 / B241
REF DART SPEC M6061T6T0.500W.58
HEAT TREAT TO -T4/-T42 CONDITION. MIN UTS = 30 KSI (60 HREW MIN)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.03 lbs

C	6061-T4 WAS 6061-T6, 0.058 WAS 0.049	CP	11.12.13
B	0.049 WAS 0.058. REASON: FACILITATE MFG	MB	11.03.22
A	NEW ISSUE	CP	10.09.22
REV.	DESCRIPTION	BY	DATE
DESIGN	GP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D4202 REV. C SHEET 1 OF 1 TITLE SPACER SCALE NTS COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	
DRAWN	GP		
CHECKED	ASS		
MFG. APPR.	EF		
APPROVED	EF		
DE APPR.	EF		
DATE	11.12.13		

METCOR INC.

560 BOUL. ARTHUR-SAUVÉ
ST-EUSTACHE, QC, J7R 5A8

Tel: 450-473-1884 / Fax: 450-491-5498

Certificat de Conformité Détaillé

Detailed Certificate of Compliance

BON DE TRAVAIL order	CHARGEMENT load
184910	1

CLIENT / customer 215

DART AEROSPACE
1270 ABERDEEN
HAWKESBURY

ON K6A 1K7

LIVRÉ À / shipped to:

DART AEROSPACE
1270 ABERDEEN
HAWKESBURY

ON K6A 1K7

COMMANDE DU CLIENT customer po	BON DE LIVRAISON DU CLIENT customer shipper no.	MATÉRIEL material	CODE DE TRAITEMENT mat'l heat code	NUMÉRO DE LOT lot number
PC19402		AL-6061		

SPÉCIFICATIONS DU PROCÉDÉ processing specifications

SOL ANNEAL

SINGLE AGING TO CONDITION T42

EXIGENCE / requirement	SPÉCIFICATIONS / specified	TESTS EXÉCUTÉS / performed	RÉSULTATS DE TESTS / results
CONDUCTIVITY	35 - 43 %IACS	20 (60kHz)	36.0 - 38.0 %IACS
HARDNESS	60 HREW MIN	20	72.5 - 74.0 HREW DURETEE MESUREE EN HR15TW = 70-71 HR15TW

QUANTITÉ quantity	POIDS weight	DESCRIPTION DES PIÈCES parts description
608	20	D4202-1 (608) SPACER REFERENCE 98699 CONTENANT; 1 BOÎTE DE CARTON

Operation	Temp. spécifiée Specified Temp	Temps de trempage Spécifié Specified Soak Temp	Atmosphère	Carbone Carbon Potential	Q-Media Q-Temp	Four # Furnace #	Date Départ Start Date	Heure d'entrée Time In	Heure de sortie Time Out	Date Complétée Date complete
1.00 CONT. INIT.										
2.00 Degrease										
3.00 PREPARING	COMPTAGE									
4.00 PREHEAT 1	529°C	0:30	air			701				
5.00 WATER TEN										
6.00 SOL ANNEA	529°C	0:15	AIR		WATER 32MAX	701				

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1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

LIVRÉ À / shipped to:

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

Operation	Temp. spécifiée Specified Temp	Temps de tremp Spécifié Specified Soak Temp	Atmosphere	Carbone Carbon Potential	Q-Media Q-Temp	Four # Furnace #	Date Départ Start Date	Heure d'entrée Time In	Heure de sortie Time Out	Date Complétée Date complete
7.00 QUENCHDE										
8.00 WATER TEN										
9.00 PREPARING										
10.00 AGE HARDE		96:00								
11.00 HARDN INS										
12.00 CONDUCT										
13.00 FINAL INSP							04-10-2013			04-10-2013

COMMENTAIRES / comments

Le traitement thermique a été fait en utilisant des équipements en conformité avec la spécification demandée.
Toutes les opérations de traitement thermique ont été faites en conformité avec les requis de la spécification demandée et toutes les vérifications et les tests demandés ont été faites et documentés.
Aucun changement ou dérogation n'a été faite par rapport au traitement thermique demandé.
On certifie que le matériel a été fabriqué, échantillonné, testé et inspecté en accord avec les spécifications du matériel et le bon de commande et le matériel rencontre les exigences spécifiées.

All the heat treatment processing performed on this order was accomplished using heat treatment equipment compliant with the requested heat treatment specification.

All the heat treatment operations were accomplished in accordance with the requested/required heat treatment specification and all required verifications test have been performed and documented.

No unauthorized changes or deviations to required heat treatment specifications or procedures have been performed.

We certify that the material was manufactured, sampled, tested and inspected in accordance with the material specification and the purchase order and was found to meet the requirements.

APPROUVÉ par / Approved by:

J. B. Oker



DATE: 2013-04-11

/ Nous certifions que toute l'information comprise sur ce rapport est exacte et conforme aux requis du client. / We certify that all the information on this report is exact and in accordance with the order requirements.



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO19402

Purchase Order Date 3/22/13

PO Print Date 3/22/13

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Order From : VC-MET004

METCOR INC.
560 BOUL. ARTHUR SAUVE
SAINT-EUSTACHE, QC J7R 5A8
CA

Contact Name		Buyer	Chantal Lavoie
Vendor Phone	450 473 1884	Requisition Nbr	
Vendor Fax	450 491 5498	Tax Resale Nbr	10127-2607
Vendor Account Nbr		Terms	Net 30
		Currency	CAD
		FOB	Destination-Collect

Ship To : DART AEROSPACE LTD 1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

FAKED
04/13/13

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	98699	D4202-1 SPACEF	4/03/13 Yes	✓ 608.00	FedEx PI collect	\$1.0000	\$608.00

Special Inst: HEAT TREAT TO -T4 CONDITION
MIN.UTS = 30KSI (60HREW MIN.)

DETAIL C OF C REQUIRED

PO Total: \$608.00

SP13-4-12

CERTIFICATE OF CONFORMITY
REQ'D UPON DELIVERY

Change Nbr: 1

Change Date: 3/22/13

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required - YES NO